

Date: Friday, 30/05/2008 10:12:38 AM  
 User: Julie Lecocq

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: FLOOR WINDOW		
Job Number	: 39598			Part Number	: D3295041		
Estimate Number	: 10848			Drawing Number	: D3295 REV D		
P.O. Number	:			Project Number	: N/A		
This Issue	: 30/05/2008	S.O. No.	:	Drawing Revision	: D		
Prsh Rev.	: NC			Material	:		
First Issue	: / /	Type	: MACHINED PARTS	Due Date	: 10/06/2008 Qty: 12 Um: Each		
Previous Run	: 37036						
Written By	:						
Checked & Approved By	: JLD 08.5.30						
Comment	: Est. C 05.06.20 D3295-1 no longer made in-house KJ/JLM Est Rev:D Added DT8822 07-03-20 JLM Est Rev:E Returned Manufacturing In House 07-06-26 JLM						

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	MLEXS125 0004	1/8" 9034 Lexan Sheet <i>32,</i>
		Comment: Qty.: 1.3020 sf(s)/Unit Total : 15.6240 sf(s) 1/8" Thick Lexan 9034 sheet Batch: <u>106403</u> <b>RB 8-6-3</b>
2.0	WATER JET	FLOW WATER JET 
		Comment: FLOW WATER JET 1-Cut as per Dwg D3295 Dwg Rev: <u>D</u> <b>RB 8-6-3</b> Prog Rev: <u>D</u>
		2-Remove plastic and wrap in saran wrap.
		2-Deburr if necessary
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE <b>RB 8-6-3</b>
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE
4.0	QC8	SECOND CHECK 
		Comment: SECOND CHECK <i>{ 0866603 (x20)</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 30/05/2008 10:12:38 AM  
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOOR WINDOW

Job Number: 39598

Part Number: D3295041

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per Dwg D3295.

Put window in plastic wrap.

SAD 08/06/03

(20)

6.0 D27281 Dart Logo Label - small



Comment: Qty.: 1.0000 Each(s)/Unit Total : 12.0000 Each(s)

Dart Logo label small

Pick:

Qty	Part Number	Description	Batch
1	D2728-1	Decal	R39012

(PC) (H)

SAD 08/06/03

(20)

7.0 QC5 INSPECT WORK TO CURRENT STEP



INSPECT WORK TO CURRENT STEP

08/06/03 (17)

Comment: INSPECT WORK TO CURRENT STEP

8.0 PACKAGING 1 PACKAGING RESOURCE #1



(PA)

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 217

8/6/04

SP

9.0 QC21 FINAL INSPECTION/W/O RELEASE



08/06/05 (J)

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-06-04

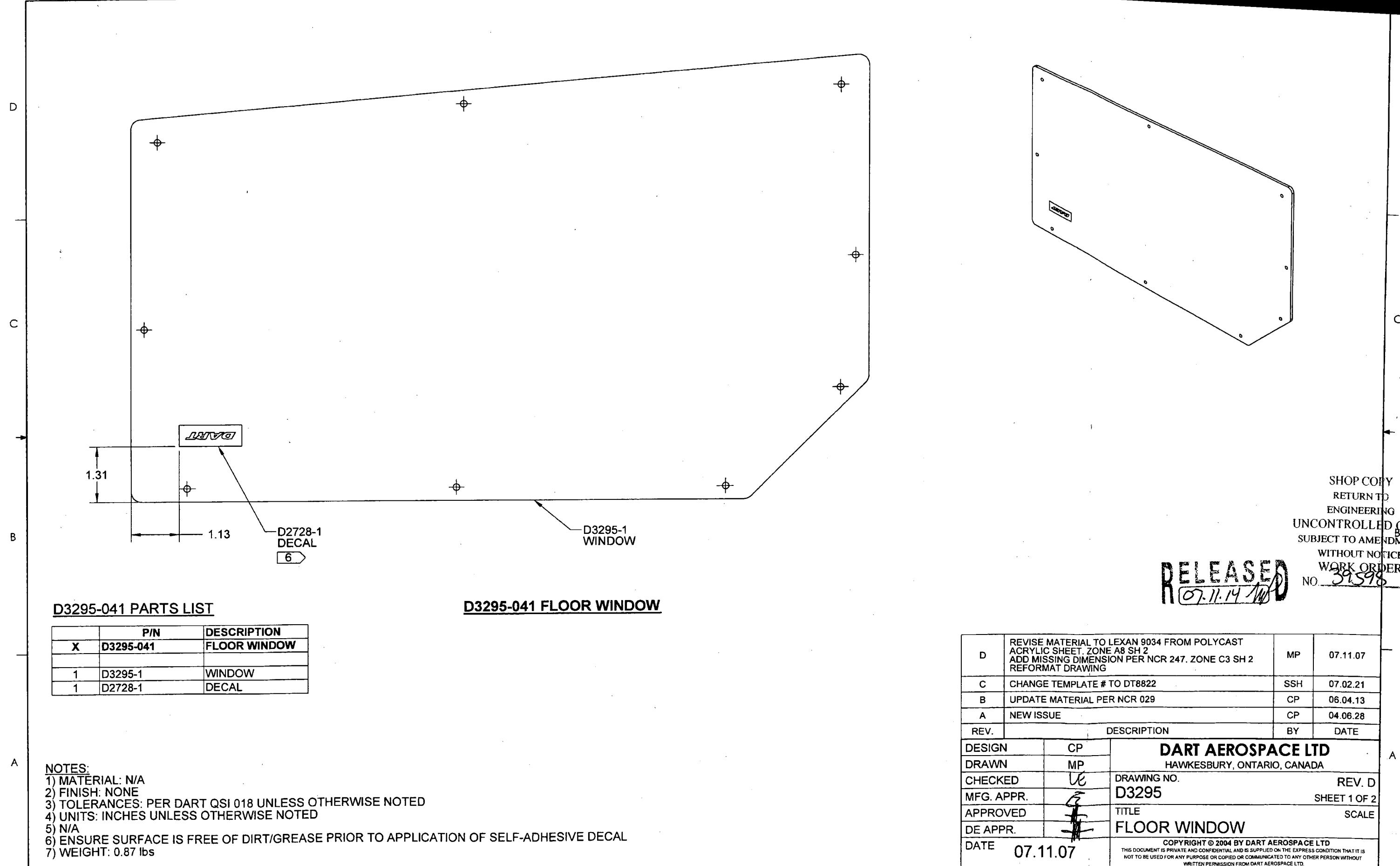
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3295-041 PAR #: N/A Fault Category: ~~Tool/Fab Ass~~ <sup>ned# small</sup> NCR:  No DQA:  Date: 08/06/05  
 QA: N/C Closed:  Date: 08/06/05

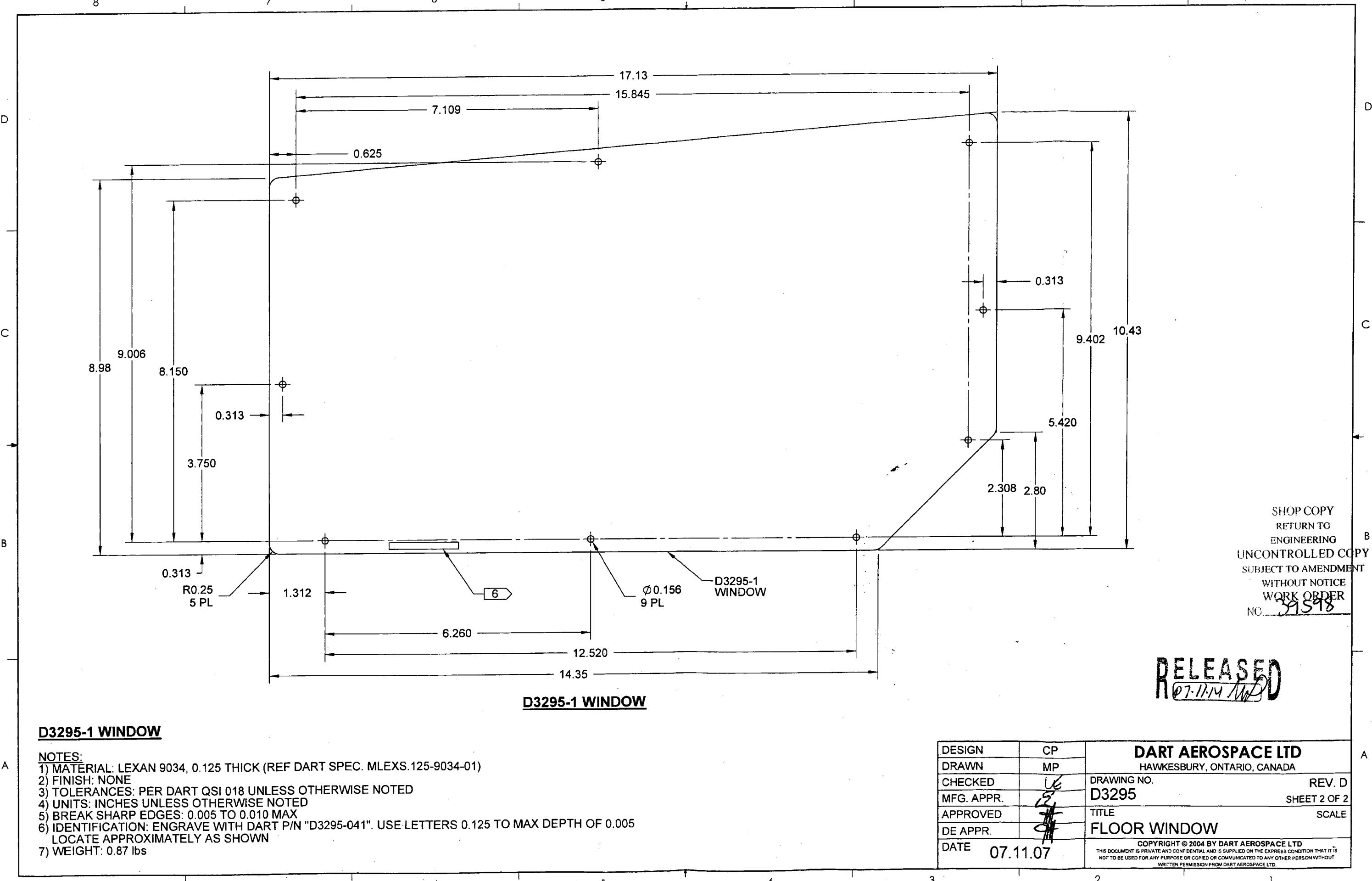
		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08.06.04	60	3 windows were found with heavy blast marks. R.C: Abrasive in the water jet process.	J QSIU12	Scrap: destroy Qty 3, No replace	SAJ 07/06/04	J 08.06.04 QSIU12	J 08.06.04 QSIU12	J 08.06.04

NOTE: Date & initial all entries

8 7 6 5 4



D	REVISE MATERIAL TO LEXAN 9034 FROM POLYCAST ACRYLIC SHEET. ZONE A8 SH 2 ADD MISSING DIMENSION PER NCR 247. ZONE C3 SH 2 REFORMAT DRAWING	MP	07.11.07
C	CHANGE TEMPLATE # TO DT8822	SSH	07.02.21
B	UPDATE MATERIAL PER NCR 029	CP	06.04.13
A	NEW ISSUE	CP	04.06.28
REV.	DESCRIPTION	BY	DATE
DESIGN	CP	<b>DART AEROSPACE LTD</b>	
DRAWN	MP	HAWKESBURY, ONTARIO, CANADA	
CHECKED	VE	DRAWING NO.	REV. D
MFG. APPR.	7	D3295	SHEET 1 OF 2
APPROVED	7	TITLE	SCALE
DE APPR.	7	FLOOR WINDOW	
DATE	07.11.07	COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



### D3295-1 WINDOW

#### NOTES:

- MATERIAL: LEXAN 9034, 0.125 THICK (REF DART SPEC. MLEXS.125-9034-01)
- FINISH: NONE
- TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- UNITS: INCHES UNLESS OTHERWISE NOTED
- BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- IDENTIFICATION: ENGRAVE WITH DART P/N "D3295-041". USE LETTERS 0.125 TO MAX DEPTH OF 0.005 LOCATE APPROXIMATELY AS SHOWN
- WEIGHT: 0.87 lbs

DESIGN	CP	DART AEROSPACE LTD			
DRAWN	MP	HAWKESBURY, ONTARIO, CANADA			
CHECKED	LG	DRAWING NO.			
MFG. APPR.	ZL	REV. D			
APPROVED	TH	D3295			
DE APPR.	CH	TITLE			
DATE	07.11.07	SCALE			
FLOOR WINDOW					
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DART AEROSPACE LTD	Work Order:	39598
Description: Floor window	Part Number:	D 3295 /W
Inspection Dwg: D 3295 /W Rev: D		Page 1 of 1

# **FIRST ARTICLE INSPECTION CHECKLIST**

## X First Article      Prototype

Measured by:	TP	Audited by:		Prototype Approval:	A
Date:	8-6-3	Date:	08/06/03	Date:	A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	